



007236

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RBW5305G00131-3G

Job Sheet 184927



Part No: RBW5305G00131-3G

Job Qty: 2 each

Part Name: Tail Boom Lifting Sling & Attachment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5305G00131-3G REV 3 IPP REV A 18.05.28 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/1/18	11/1/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	2 pcs	11/1/18	11/1/18	0.00	2.00	Small Fab-3		MLC
120	QC	2 pcs	11/1/18	11/1/18	0.00	0.00	QC5		MLC
130	Packaging	2 pcs	11/1/18	11/1/18	0.00	0.00	Packaging3-1		MLC
140	QC21-SA	2 Ea	11/1/18	11/1/18	0.00	0.00	QC21		MLC

Part Op 110 - 1-Assemble as per DWG. 2- Transfer drill placard RB41011 on RBW5305G00131-3G-1 and insert drive screws
Descriptions: Load test assembly as per DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Start up Operation	
3001T54	Turnbuckle, Jaw to Jaw	8 (4 ea)	110-Small Fab	5021040
3339T2	Web Sling Protector	8 (4 ea)	110-Small Fab	5122145
3383T329 - Nylon, 120" long	Web Sling	4 (2 ea)	110-Small Fab	5122141
3383T329 - Nylon, 48" long	Web Sling	4 (2 ea)	110-Small Fab	5139467
90081A077	Drive Screw #2 1/4" Long	8 Ea (4 ea)	110-Small Fab	5122583
90108A417	Flat Washer 3/8" Plated	8 Ea (4 ea)	110-Small Fab	5048890
94895A815	Hex Nut, Steel 3/8" ID x 5/8" OD	8 (4 ea)	110-Small Fab	5044121
CR1018437	Shackle w / Screw Pin	16 (8 ea)	110-Small Fab	5122140
CR1018455	Shackle w / Screw Pin	2 (1 ea)	110-Small Fab	5126663
CR1018491	Shackle w / Screw Pin	4 (2 ea)	110-Small Fab	5126665
GU589617	Oblong Link Ring, Weldless	2 (1 ea)	110-Small Fab	5126664
RBW5305G00131-3G-1	Spreader Plate	2 Ea (1 ea)	110-Small Fab	5126666
RBW5305G00131-3G-3	Threaded Rod	2 Ea (1 ea)	110-Small Fab	5124687
RBW5305G00131-3G-5	Rod Mount	4 Ea (2 ea)	110-Small Fab	5131237
RBW5305G00131-3G-79	Spanset Green Web Sling (2000 kg) W / Ø5/8 Elongated D-Ring	4 Ea (2 ea)	110-Small Fab	5119228
RBW5305G00131-3G-81	Spanset Green Web Sling (2000 kg) W / Ø5/8 Elongated D-Ring	4 Ea (2 ea)	110-Small Fab	5122628
RBW5305G00131-3G-83	Securtech Sleeve, Web Sling Protector Pad, W / Velcro	8 Ea (4 ea)	110-Small Fab	5122632
RBW5305G00131-3G-89	Sticker, "Upper Right"	2 Ea (1 ea)	110-Small Fab	5127904
RBW5305G00131-3G-91	Sticker, "Upper Left"	2 Ea (1 ea)	110-Small Fab	5127902
RBW5305G81851-3G	T/B Lift Fittings (Includes Left & Right Bracket)	2 Ea (1 ea)	110-Small Fab	5140666

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	2	743	0
110-Small Fab	3001T54	8	0	0
	3339T2	8	0	0
	3383T329 - Nylon, 120" long	4	0	0
	3383T329 - Nylon, 48" long	4	0	0
	90081A077	8	88	0
	90108A417	8	92	0
	94895A815	8	0	0
	CR1018437	16	0	0
	CR1018455	2	0	0
	CR1018491	4	0	0
	GU589617	2	0	0
	RBW5305G00131-3G-1	2	0	0
	RBW5305G00131-3G-3	2	0	0
	RBW5305G00131-3G-5	4	6	0
	RBW5305G00131-3G-79	4	0	0
	RBW5305G00131-3G-81	4	0	0
	RBW5305G00131-3G-83	8	0	0
	RBW5305G00131-3G-89	2	0	0
	RBW5305G00131-3G-91	2	0	0
	RBW5305G81851-3G	2	0	0

Part Specifications

Specifications could not be found.



Container No: S140626



Part: RBW5305G00131-3G

Job No: 184927

Serial No/Batch: S140626

Revision: 3

Inspector:

Exp Date:

Instructions:

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Email: sales@dartaero.com
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Plex 10/18/18 11:12 AM Dart.lajeunesse.marie

Date: 12/28/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

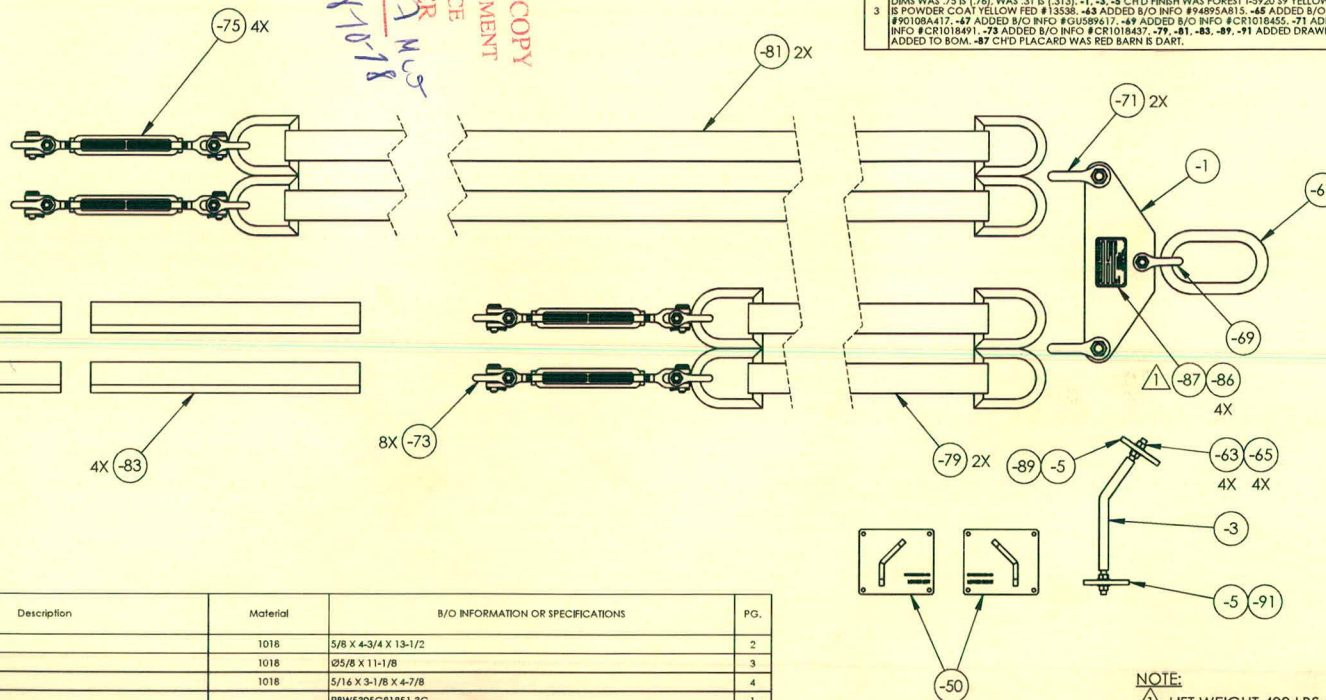
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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WORK ORDER
NO. 184924 MCB
1810-18



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SPREADER PLATE	1018	5/8 X 4-3/4 X 13-1/2	2
			-3	1	THREADED ROD	1018	Ø5/8 X 11-1/8	3
			-5	2	ROD MOUNT	1018	5/16 X 3-1/8 X 4-7/8	4
			-50	1	T/B LIFT FITTINGS		RBW5305G00131-3G	1
	B/O		-63	4	HEX NUT	STEEL	3/8-24 MCMaster-CARR #94895A815	1
	B/O		-65	4	WASHER	STEEL	Ø7/16 I.D. MCMaster-CARR #90108A417	1
	B/O		-67	1	ORLONG LINK RING, WELDLESS	STEEL	Ø3/4 EUGENE EQUIPMENT #GUS89617	1
	B/O		-69	1	SHACKLE W/ SCREW PIN	STEEL	Ø1/2 EUGENE EQUIPMENT #CR1018455	1
	B/O		-71	2	SHACKLE W/ SCREW PIN	STEEL	Ø3/4 EUGENE EQUIPMENT #CR1018491	1
	B/O		-73	8	SHACKLE W/ SCREW PIN	STEEL	Ø7/16 EUGENE EQUIPMENT #CR1018437	1
	B/O		-75	4	TURNBUCKLE, JAW TO JAW	STEEL	1/2-13 UNC MCMaster-CARR #3001T54	1
			-79	2	SPANSET GREEN WEB SLING (2000 kg) W/ Ø5/8 ELONGATED D-RING	SYNTHETIC, TYPE II	2 PLY: 2in. X 50in. EUGENE EQUIPMENT (REF. MED. CAP. TYPE II TT2-502)	5
			-81	2	SPANSET GREEN WEB SLING (2000kg) W/ Ø5/8 ELONGATED D-RING	SYNTHETIC, TYPE II	2 PLY: 2in. X 120in. EUGENE EQUIPMENT (REF. MED. CAP. TYPE II TT2-502)	6
			-83	4	SECURTEX SLEEVE, WEB SLING PROTECTOR PAD, W/ VELCRO	SYNTHETIC W/ PADDING	FOR 2in. STRAP X 18in. EUGENE EQUIPMENT	7
	B/O		-86	4	DRIVE SCREW	STEEL	#2 X 1/4 MCMaster-CARR #90081A077	1
			-87	1	DART PLACARD	ALUMINUM	#RB41011	1
	B/O		-89	1	STICKER, "UPPER RIGHT"	CLEAR PLASTIC	3/16 BLACK LETTERS SIGNS NOW	8
	B/O		-91	1	STICKER, "UPPER LEFT"	CLEAR PLASTIC	3/16 BLACK LETTERS SIGNS NOW	9

REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CHD ENGRAVE NOTE P/N -5, CORRECTED P/N -75 TO -21 & -49.	5/28/2009	RJC	
B	CHANGED B.O.M. -3 QTY FROM 2 TO 1, -45 LENGTH FROM 39-1/8 TO 29-1/4, ALSO ADDED PAGE FOR -33 THRU -41 DRAWINGS, ADDED MISSING DIMENSION Ø1.125 TO -43, PER DAVE, ALSO ADDED TOLERANCE TO O.D. OF -45.	10/5/2009	WP	DW
C	ADDED -3G TO END OF TOOL NUMBER, ADDED RADIUS ØK TO -29 & -31, CHD FINISH FROM BLACK OXIDE TO ZINC YELLOW -45, -47, & -49.	3/29/2010	RJC	DW
1	ADDED -50 TAIL BOOM LIFT FITTINGS RBW5385G01851.	3/29/2010	WP	RW
2	DELETED PART No. 1-7 THRU -61 AND -85, TAIL BOOM BRACKET ASSEMBLY IS REMOVED FROM THIS TOOL AND ADDED TO TOOL No. RBW5305G00232-3G TAIL BOOM TROLLEY, REDUCED PAGES FROM 8 TO 2, CHANGED -1, -3, & -5 FROM PART TO POWDER COAT, ALSO ADDED -89 & -91 STICKERS TO REPLACE STENCILS.	6/29/2010	WP	DW
2D	CORRECTED P.N. ON -50 IN BOM WAS RBW5385G01851.	3/6/2012	SE	RW
3	UPDATED TO NEW DRAFTING STANDARDS, CHD TITLE BLOCK WAS RED BARN IS DART, CHD TOLERANCE ON NON-CRITICAL PARTS, -1 CHD DIM WAS 4.0 IS (3.9), WAS -625 B (.625), -8 CHD DIMS WAS .75 IS (.76), WAS .31 IS (.313), -1, -3, -8 CHD FINISH WAS FOREST 1-5020 99 YELLOW RIBBON IS POWDER COAT YELLOW FED #13538, -43 ADDED B/O INFO #94895A815, -45 ADDED B/O INFO #90108A417, -47 ADDED B/O INFO #GUS89617, -49 ADDED B/O INFO #CR1018455, -71 ADDED B/O INFO #CR1018491, -73 ADDED B/O INFO #CR1018437, -79, -81, -83, -89, -91 ADDED DRAWINGS, -84 ADDED TO BOM, -87 CHD PLACARD WAS RED BARN IS DART.	7/1/2014	DPD	JAG

NOTE:

▲ LIFT WEIGHT 400 LBS (1750 N).

		TITLE	
		TAIL BOOM LIFTING SLING & ATTACHMENT	
DWG NO.		REV	
RBW5305G00131-3G		3	
MATERIAL		DRAWN BY: DUERFELDT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>D. Wied</i>	
.XXX ± .005		FRACTIONS ± 1/32	
.XX ± .01		DECIMALS ± .005	
.X ± .1		ANGLES ± 5°	
1. BREAK ALL SHARP EDGES .015 x 45°		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE 1:8		DATE 5/4/2009	
		SHEET 1 OF 10	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

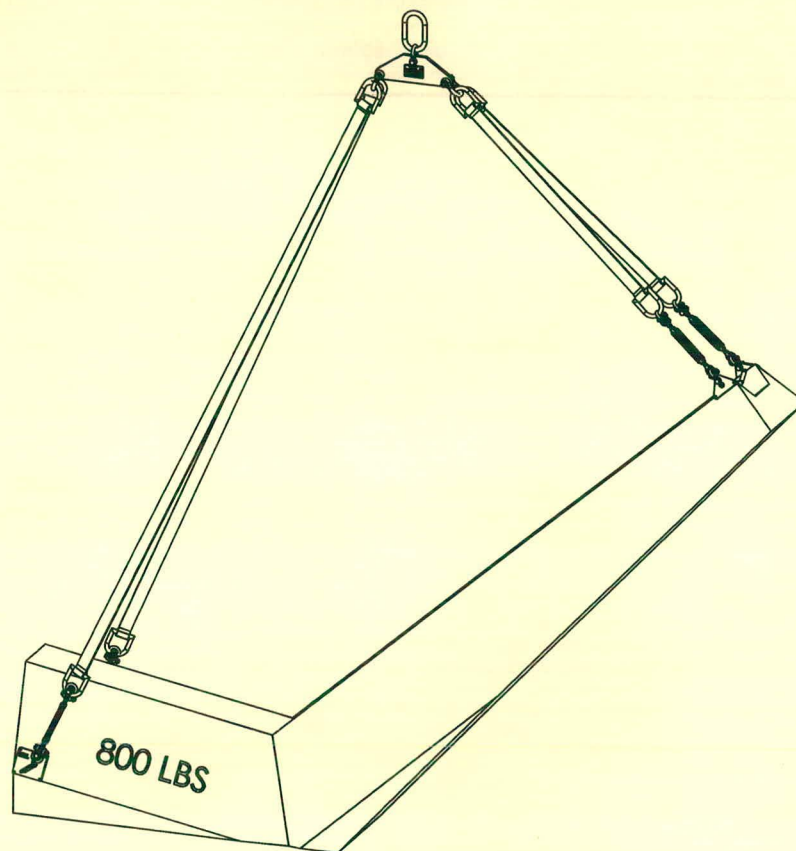
Work Order update only ☐

Work Order: _____ Part No. <u>RBW5305G00131-3G</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval <i>M. Lee</i> May 28, 2018		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
- McMaster Carr 3383T329, Nylon, 48" long Web Sling can be used as an alternative to SpandSet Green Web Sling (2 ply, 2", 50" long) - McMaster Carr 3383T329, Nylon, 120" long Web Sling can be used as an alternative to SpandSet Green Web Sling (2 ply, 2", 120" long) - McMaster Carr 3339T2 Web Sling Protector can be used as an alternative to Securtex Web Sling Protector				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended. - The drawing will be updated to reflect this change.					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☒	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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FIRST ARTICLE WEIGHT TEST



INSPECTION & TESTING PROCEDURES FOR THE RBW5305G00131-3G, TAIL BOOM LIFTING SLING & ATTACHMENT. THIS ASSEMBLY IS DESIGNED EXCLUSIVELY FOR HOISTING AND INSTALLING/REMOVING THE TAIL BOOM. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON A OVERHEAD LIFTING DEVICE. ATTACH THE LIFTING FITTINGS & ROD MOUNTS TO AN APPROPRIATE TEST WEIGHT OF 800 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: _____

TESTER: Michael

S.N.: 5140 626

DATE: 2018-12-28

DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE TAIL BOOM LIFTING SLING & ATTACHMENT			
DWG NO.	REV	CUSTOMER 1 OF 1	
RBW5305G00131-3G	3		
SCALE	DATE	SHEET	
1:30	7/1/2014	10 OF 10	

